

3392

86634

Page 1

Work Order ID 86634

Friday, July 06, 2012 11:45:19 AM

Item ID: D4547-5

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Vertical Linkage Tube

Stop *NS2*

Start Date: 7/5/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 7/19/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: *UMK*Date: *2-07-06*

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4547

B

0.00

100

100

Doosan

Doosan Lathe

Memo

MILL/TURN AS PER DWG

DWG REV: _____

FOLIO REV: _____

DEBURR

Manual

0.00

110

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

*12-7-31**12-08-02**2**2**PTC*

W/O: 86634

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2856-600

PAR #:

Fault Category: Machining

NCR: Yes No

DQA: AutDate: 12/08/13

Resolution:

Disposition: use as isQA: N/C Closed: SDDate: 12/08/14NCR: 12-11662

WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
120802	100	DEPTH OF HOLE, 1.00" (2W C3-3) IS MACHINED TO 1.20". R.C. PROCESS	DAS 22 1208-02	ACCEPTABLE DEVIATION.	SD 08/02/12	D.A 12/08/03	DAS 22 1208-02	DAS 16 12/08/07

NOTE: Date & initial all entries

Work Order ID 86634

Friday, July 06, 2012 11:45:19 AM

86634

Page 2

Item ID: D4547-5

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Vertical Linkage Tube

Start Date: 7/5/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 7/19/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

B.a 12/08/03

2

0

150

Identify as per dwg & Stock Location: **8241A** 0.00***150***

Packaging

Memo

0.00

Packaging

2x

12-8-7.

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

12/8/07

MLT 12/08/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, July 06, 2012 11:45:17 AM

Page 1

Work Order ID: 86634

Parent Item: D4547-5

Parent Item Name: Vertical Linkage Tube

Start Date: 7/5/2012

Required Date: 7/19/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 12-01-10 JLM VERIFIED BY:DD
DWG REV.B DD VERF:EC IPP REV:B 12.06.12 AS PER

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M174R0.375 17-4 SS ROUND BAR .375"		Purchased	No			100	f	24.0000	2.9	6.1052632			

Location

Loc Qty

Loc Code

MAT030

24

121546

24

6.2

12-07-31

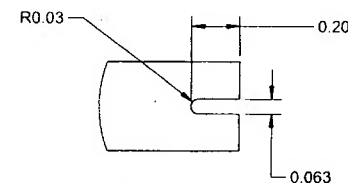
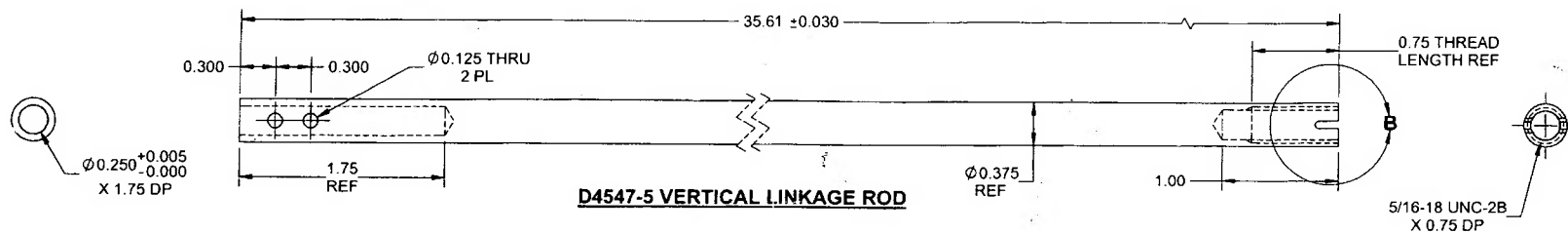
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



NOTES:

- 1) MATERIAL: 17-4 PH / S17400 / TYPE 630 STAINLESS STEEL ROUND BAR
PER AMS 5643 / ASTM A564 (REF DART SPEC M17-4-R0.375)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.08 lbs

DESIGN	RP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	SP	DRAWING NO. D4547	REV. B
MFG. APPR.	SP	SHEET 3 OF 3	
APPROVED	SP	TITLE VERTICAL LINKAGE ASSY	SCALE NTS
DE APPR.	SP	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DATE	12.04.19		

RELEASED
R 2012-06-05

86634

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

1000 2000 3000
4000 5000 6000
7000 8000 9000
10000 11000 12000

13000 14000 15000
16000 17000 18000
19000 20000 21000
22000 23000 24000

25000 26000 27000
28000 29000 30000
31000 32000 33000
34000 35000 36000

37000 38000 39000
40000 41000 42000
43000 44000 45000
46000 47000 48000

49000 50000 51000
52000 53000 54000
55000 56000 57000
58000 59000 60000

61000 62000 63000
64000 65000 66000
67000 68000 69000
70000 71000 72000

73000 74000 75000
76000 77000 78000
79000 80000 81000
82000 83000 84000

85000 86000 87000
88000 89000 90000
91000 92000 93000
94000 95000 96000

97000 98000 99000
100000 101000 102000
103000 104000 105000
106000 107000 108000